

Date: Tuesday, 12/08/2008 11:26:17 AM
User: Linda Lacelle

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | STRUT |
| Job Number : | 41165 | | |
| Estimate Number : | 10284 | | |
| P.O. Number : | | Part Number : | D2565109 |
| This Issue : | 12/08/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D2565 REV E |
| First Issue : | / / | Project Number : | N/A |
| Previous Run : | 40012 | Drawing Revision : | E |
| Written By : | | Material : | |
| Checked & Approved By : | <u>JUD 08-8-12</u> | Due Date : | 22/08/2008 |
| Comment : | Est:F 02.04.16 Added dwg Rev.C1 NG | Qty: | 10 Um: Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.0771 f(s)/Unit Total: 10.7709 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall
(M304TR0750W049)

Batch No:

107688 2

1088501 2

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: BRAKE NC

Punch as per Dwg D2565 using DT 8313

SR 08/08/27

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

08/08/28 10 hr

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/28

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50
4:00
2:20

M-1 08/09/02

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 12/08/2008 11:26:17 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 41165

Part Number: D2565109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



(PDS)

Comment: INSPECT POWDER COAT

08-09-03

X10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 270

JS

08/09/03 (K10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03 (K10)

Job Completion



MF 08-09-03

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2565-109 PAR #: N/A Fault Category: Prod/Finishing NCR: (Yes) No DQA: (D) Date: 08/09/05
D205-633 QA: N/C Closed: (D) Date: 08/05/05

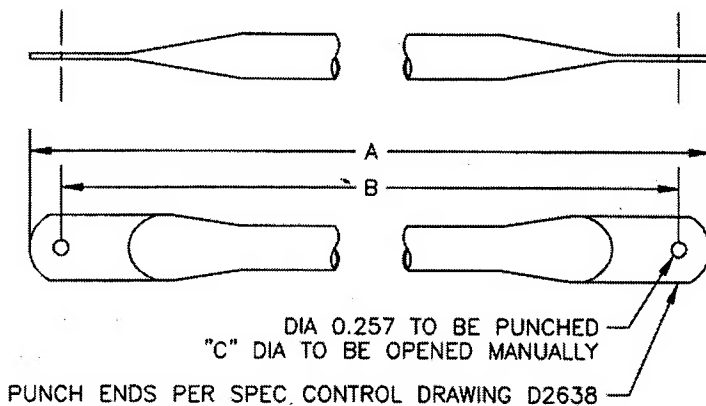
| NCR: <u>41165</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------------|--|-----------------------------|---|-----------------------------|-----------------------------|-----------------------------|-----------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>8/9/05</u> | <u>#60</u> | <u>on three struts it was found with the ink from the raw material showing through the powder coat. (only in small areas)</u> | <u>(Signature)</u> | <u>Scuff all three with 320 grit and wash with acetone.</u> | <u>(Signature) 08/09/05</u> | <u>(Signature) 08/09/05</u> | <u>(Signature) 08/09/05</u> | <u>(Signature) 08/09/05</u> |
| | | | <u>(Signature)</u> | <u>Re Powder coat as per Q57005</u> | <u>(Signature) 08/09/05</u> | <u>(Signature) 08/09/05</u> | <u>(Signature) 08/09/05</u> | <u>(Signature) 08/09/05</u> |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | | | |
|------------------|----------|----------------------------------|--|--|------------------------|
| DESIGN | | DRAWN BY | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | APPROVED | | DRAWING NO. D2565 | REV. E SHEET 1 OF 1 |
| DATE 04.05.05 | | TITLE STRUT | | SCALE 1:3 | |
| A | 96.05.03 | NEW ISSUE | | | |
| B | 97.03.15 | CORRECT D2565-111 DIM. A | | | |
| C | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603) | | | |
| D | 02.06.05 | ADD -3XX PARTS; ADD FINISH | | | |
| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | | | |

RELEASED
04.05.05



| PART # | A | B | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | - |
| D2565-109 | 12.31 | 11.51 | - |
| D2565-111 | 13.65 | 12.85 | - |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | - |
| D2565-209 | 15.16 | 14.36 | - |
| D2565-211 | 14.14 | 13.34 | - |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | - |
| D2565-309 | 20.17 | 19.37 | - |
| D2565-311 | 16.30 | 15.50 | - |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | - |
| D2565-409 | 9.34 | 8.54 | - |
| D2565-411 | 13.81 | 13.01 | - |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41165

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